

Date: Wednesday, 11/03/2009 12:59:27 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 46453	
Estimate Number : 13596	
P.O. Number :	Part Number : D38152
This Issue : 11/03/2009 S.O. No. :	Drawing Number : D3815 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 45834	Material :
Written By :	Due Date : 31/03/2009 Qty: 6 Um: Each
Checked & Approved By : <u>Jul 09.03.11</u>	
Comment : Est Rev:A 08-09-18 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4859 sf(s)/Unit Total : 2.9156 sf(s)
 2024-T3 .063 sheet
 batch: 110980

ml 09 03 24 (6)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3815
 Dwg Rev: A
 Prog Rev: A

****grain direction along 4.30" ****

2-Deburr if necessary

ml 09 03 24 (6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 24 (6)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

802/03/25 (6) PG

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

S 1/10-1 deburr if necessary
 2- Bend as per Dwg D3815

SA 09/03/05 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3815-2 PAR #: N/A Fault Category: Prod / Fin. Assy mod & smtr NCR: (Yes) No DQA: P Date: 09/05/06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: P Date: 09/05/06

NCR: <u>46453</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/3/24	# 20	During inspection found Qty ① part with holes size too large. 40.140" supposed to be 0.125. will cause problems when putting ass. together R.C. water jet offset	<u>[Signature]</u> Chief Eng	Scrap and destroy and replace Qty ①	<u>m</u> 09/03/25 Qty ①	<u>[Signature]</u> 09/03/25	<u>[Signature]</u> Chief Eng	<u>[Signature]</u> 09-03-25

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 46453

Part Number: D38152

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



(F2)

Comment: INSPECT WORK TO CURRENT STEP

S 09/05/05

(+6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(K)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MDL FL.

09/05/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-05

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: GA

SB 09/05/05

(6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



ME
09-05-05

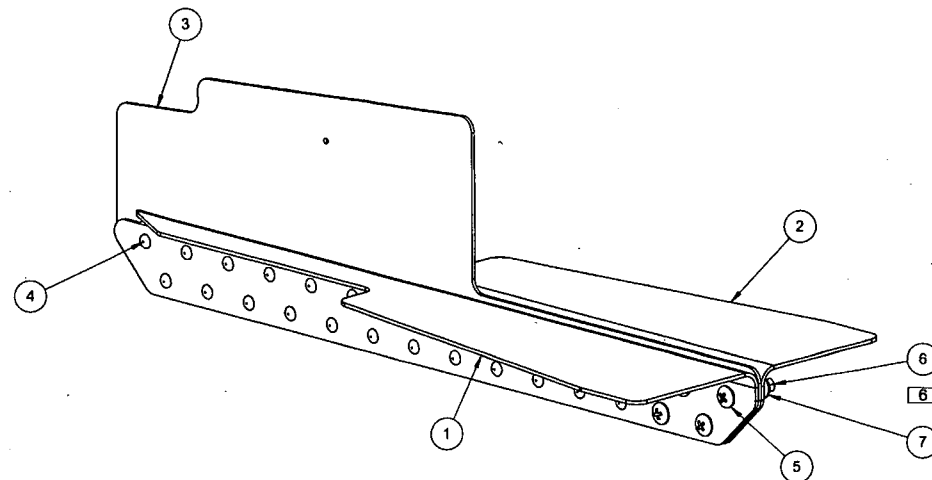
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN526C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

D3815-041 WEB ASSEMBLY

RELEASED
09/03/10

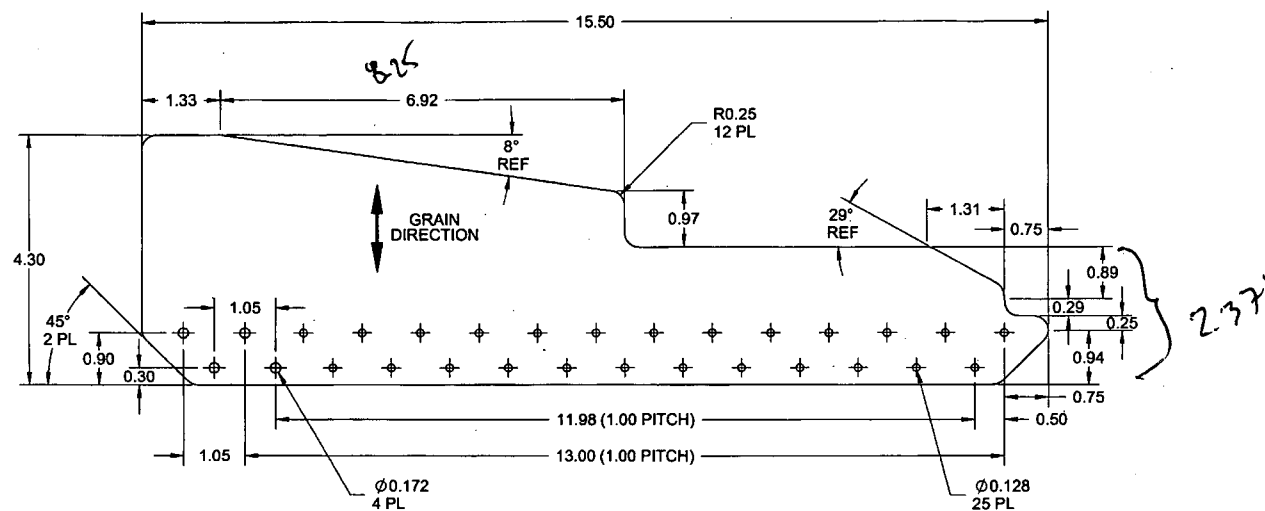
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WORK ORDER
NO. 41015

NOTES:

- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.88 lbs
- 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

A	NEW ISSUE	BY	08.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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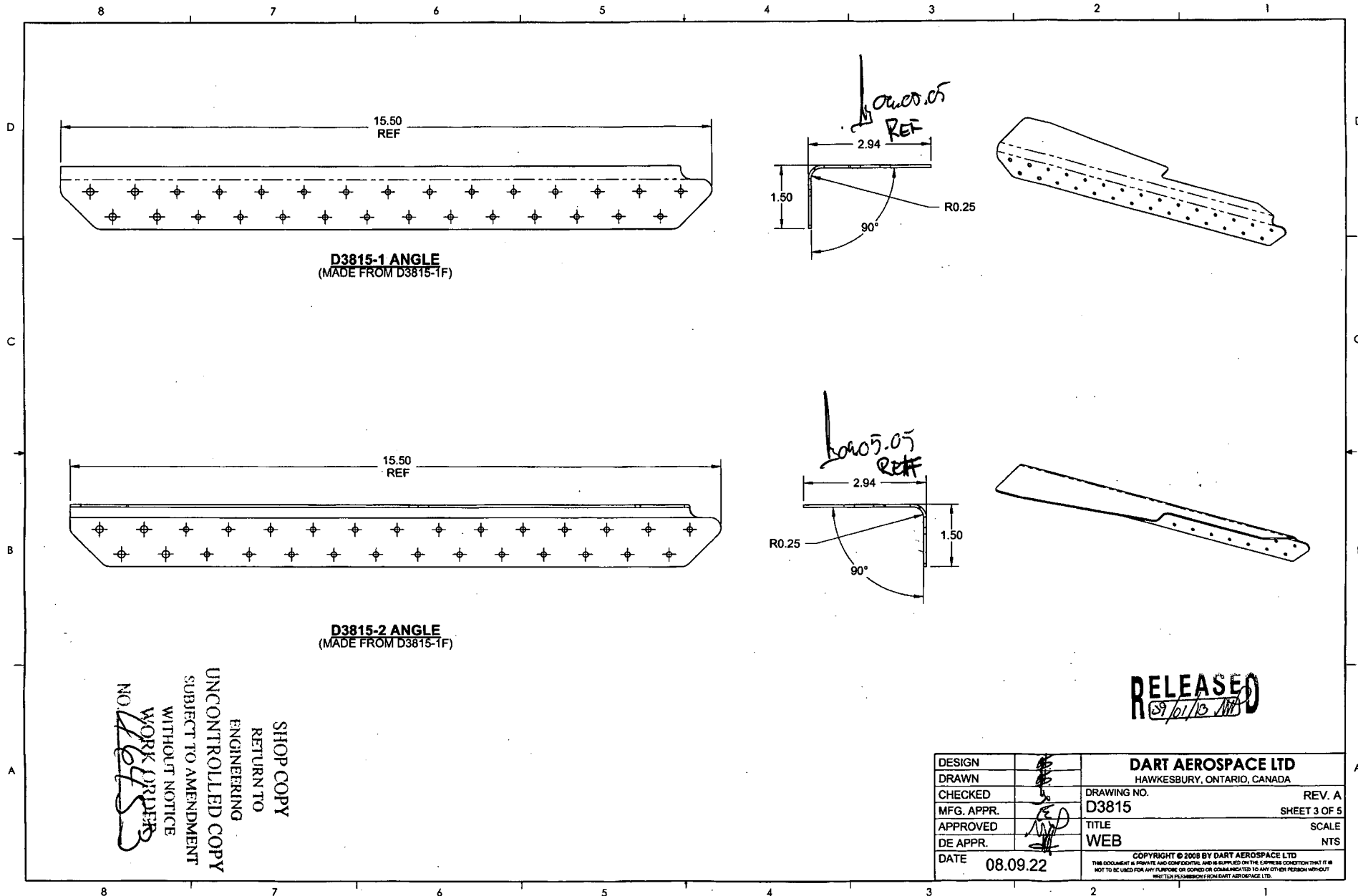
D3815-1F FLAT PATTERN

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WORK ORDER
NO. 11445

RELEASED
09/01/13

- NOTES:
- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES 0.005 TO 0.010
 - 4) IDENTIFICATION: N/A
 - 5) WEIGHT: 0.29 lbs

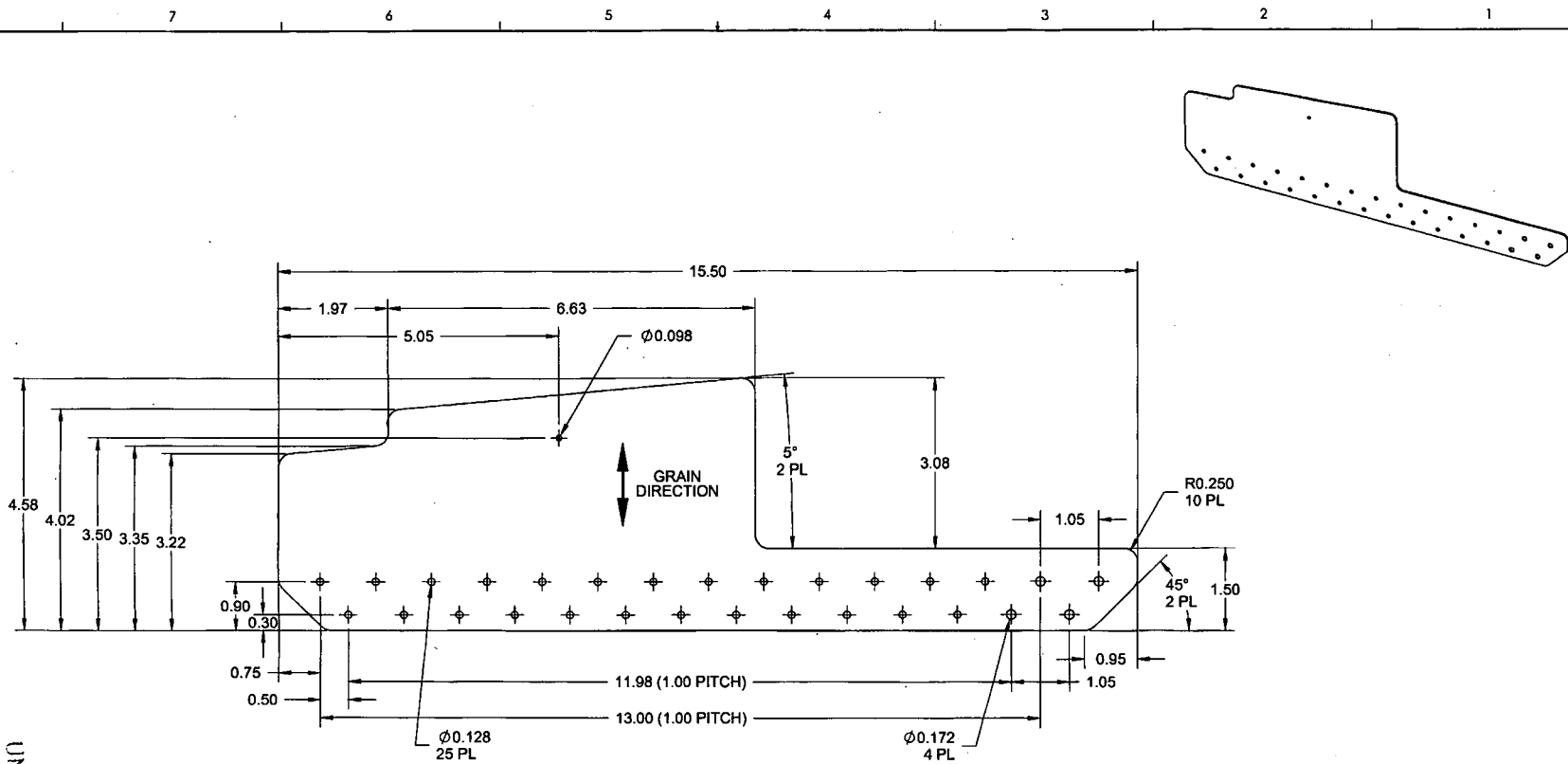
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09/01/12 MJP

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D3815-3 WEB

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09/01/13 JH

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- NOTES:
- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES 0.005 TO 0.010
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.28 lbs

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